

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014806**Date Inspected:** 04-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 8AE punch list item #556 and 9AE+9BE hold back welds. The weld designations reviewed are as follows:

8AW

1. SP102-01, 02
2. SP129-01, 02
3. SP434-11, 12
4. SP156-05, 06
5. SP485-32, 33
6. SP444-21, 23
7. SP723-28, 29
8. SP763-17, 18

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

- 8. BP148-33, 34
- 9. BP094-37, 38
- 10. BP040-33, 34
- 11. DP643-13, 14
- 12. DP651-11, 12
- 13. EP071-10, 11
- 14. EP062-12, 13

8AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 024 located at OBW8 connection plate counter weight side segment. Welder is identified as Mr. Zhai Dawei (065097). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 024 located at OBW8 connection plate counter weight side segment. Welder is identified as Mr. Hao Jianxiang (067665). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

8CE

Shield Metal Arc Welding (SMAW) base metal repair welding was performed on the bottom to side plate weld splice located on the counter weight side segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR1414 procedure.

9AE

Shield Metal Arc Welding (SMAW) base metal repair welding was performed on the bottom to side plate weld splice located on the counter weight side segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR13193 procedure.

NDT Observation

This QA Inspector observed ZPMC Magnetic Particle Testing (MT) Technician performed MT on various locations in the trial assembly yard. Locations and indications are as followed:

7BE

1. Deck plate stiffeners to deck plate hold back welds on the cross beam side of segment.

Miscellaneous Work In Progress

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

7 West

1. Segment was moved from the trail assembly line for coating.

7 East

1. Grit blasting was performed on the edge plate located on the bike path side of the segment.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz, Joe	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
